

Work Order ID 68628

Tuesday, April 19, 2011 7:48:25 AM



Page 1

Item ID: D3245-5

Accept



Setup Start



Revision ID:

Item Name: Door

Stop



Start Date: 4/19/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *H*Date: *4/04-19* Tooling:

Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3245	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FBH-4-25

FLOW CNC Waterjet

304 .032

1-Cut as per Dwg D3245

Deburr if necessary

 Dwg Rev: *B* Prog Rev: *B* 2-

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

FBH-4-25

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

S. slacks

Quality Control



W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0:00

Brake NC

Brake NC

Memo

0.00

Deburr if necessary Form D3245-5 as per Dwg D3245 Identify as D3245-5

(15)

SB 1104/26

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

SB 1104/27

(15)

150

Identify as per dwg & Stock Location C4

0.00

Packaging

Packaging

Memo

0.00

SB 1104/28

(15)

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Page 3

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Item Name: Door

Start Date: 4/19/2011 Start Qty: 10.00

Accept



Setup

Start



Stop



Required Date: 4/21/2011 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Quality Control

Memo

0.00

11/4/21
MF
11-04-27

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Picklist Print

Tuesday, April 19, 2011 7:48:32 AM

Page 1

Work Order ID: 68628



Parent Item: D3245-5



Parent Item Name: Door

Start Date: 4/19/2011

Required Date: 4/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A□04.07.07□New issue□KJ/JLM□

IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 		Purchased		No		100	sf	113.0000	0.804	8.463158	11.		

304/316 .032 Sheet

Location	Loc Qty	Loc Code
020	17	
109023	10	
109057	7	
MAT020	96	
117379	96	

169023

(14)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68626
Description: Angle Plate	Part Number:	D3245-5
Inspection Dwg: D3245	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

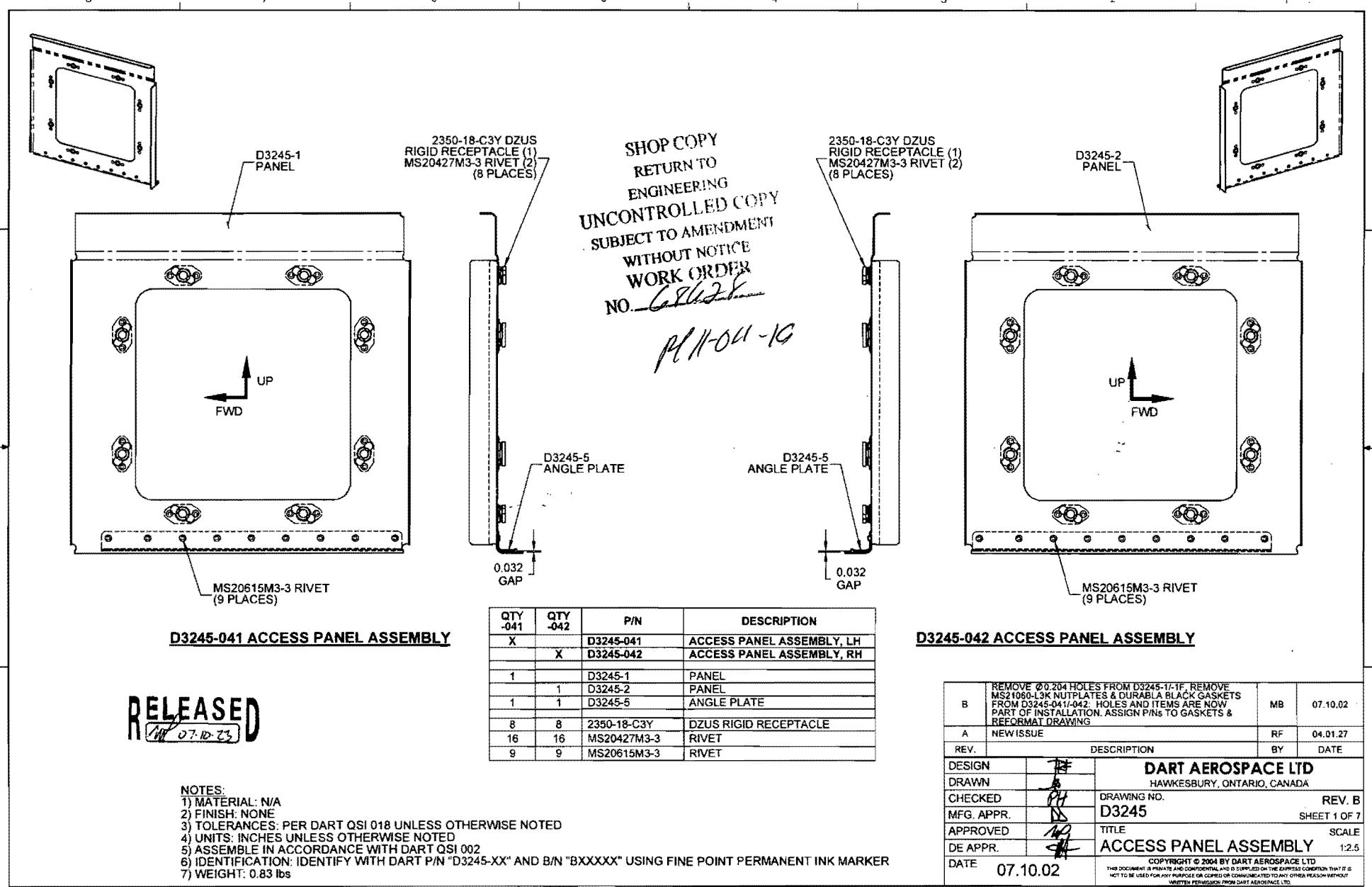
Measured by:	1B	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	11-4-05	Date:	<i>11/04/05</i>	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	08.09.04	New Issue		KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

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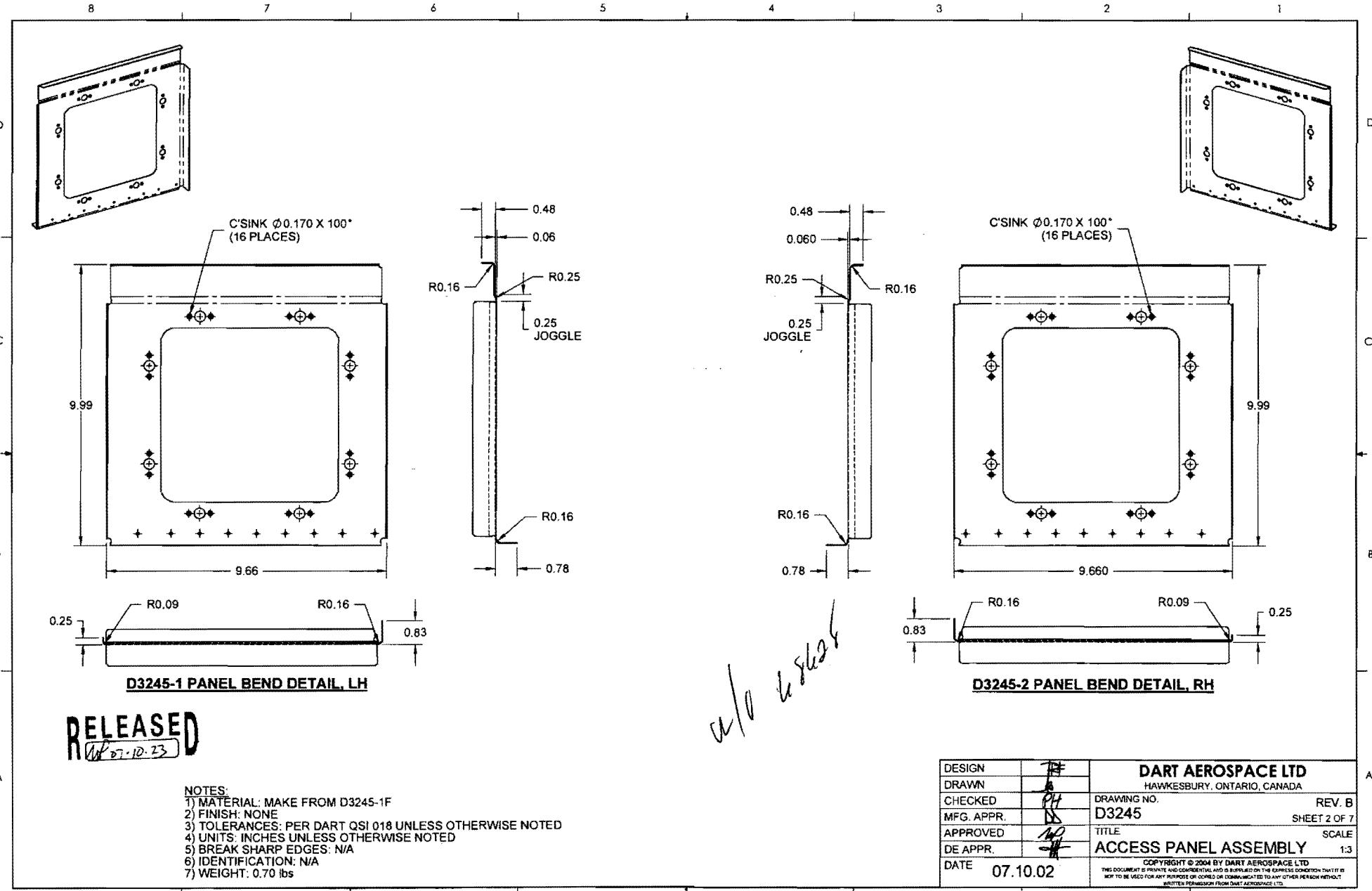
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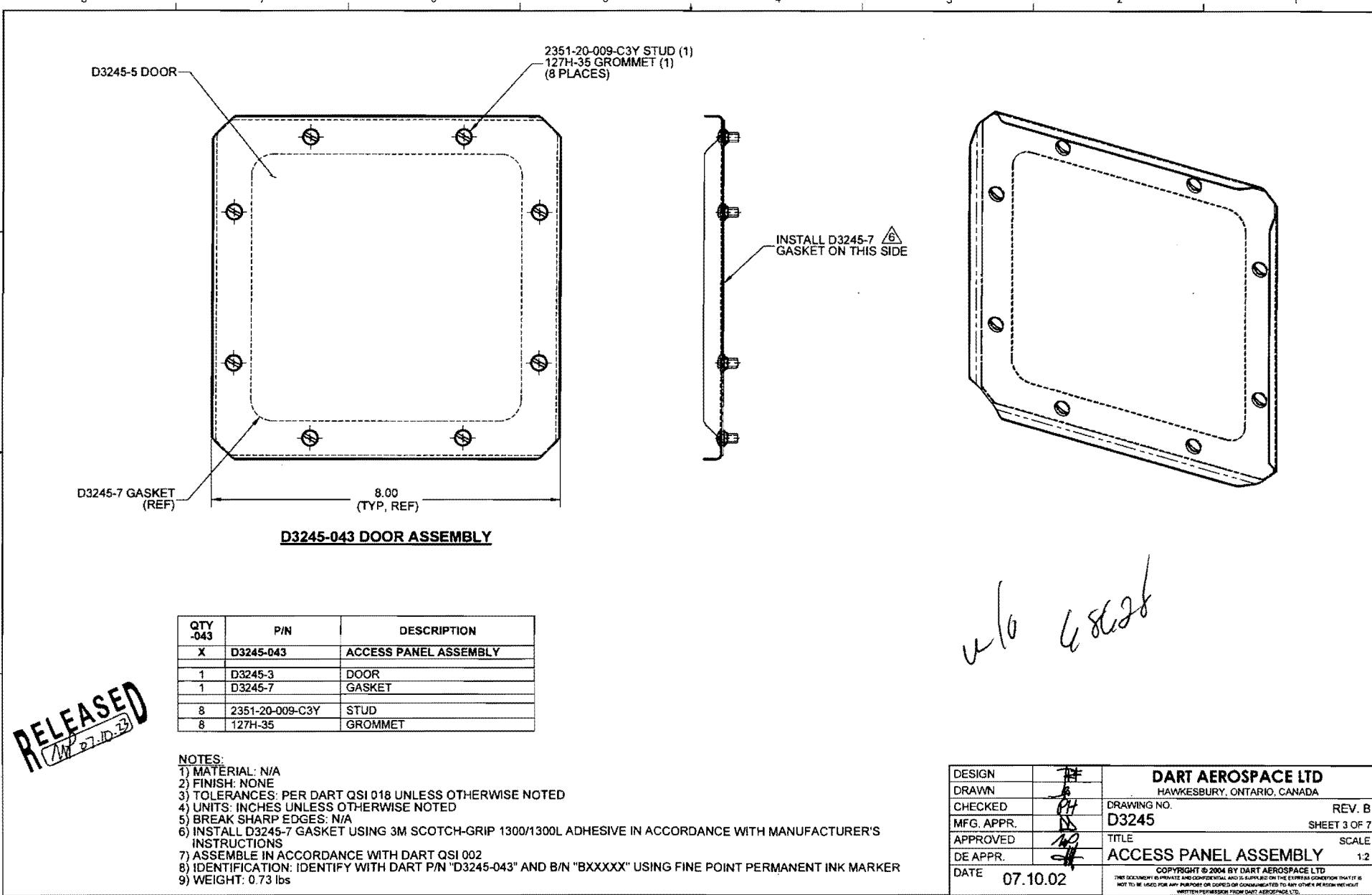
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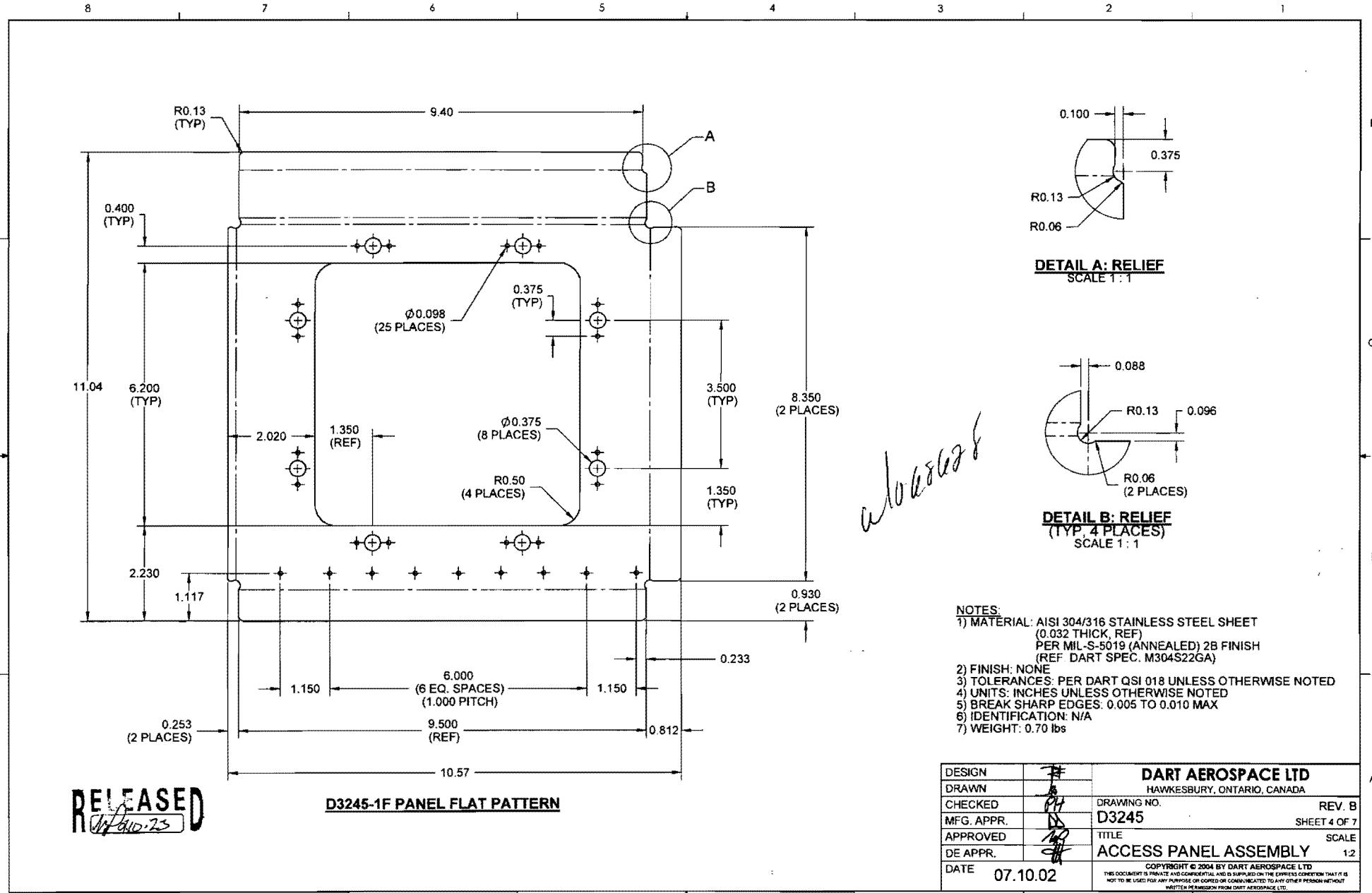
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RELEASED
1/19/23

D3245-1F PANEL FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	<u>PF</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<u>BS</u>			
CHECKED	<u>PH</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>DS</u>	D3245	SHEET 4 OF 7	
APPROVED	<u>MP</u>	TITLE	SCALE	
DE APPR.	<u>CH</u>	ACCESS PANEL ASSEMBLY 1:2		
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

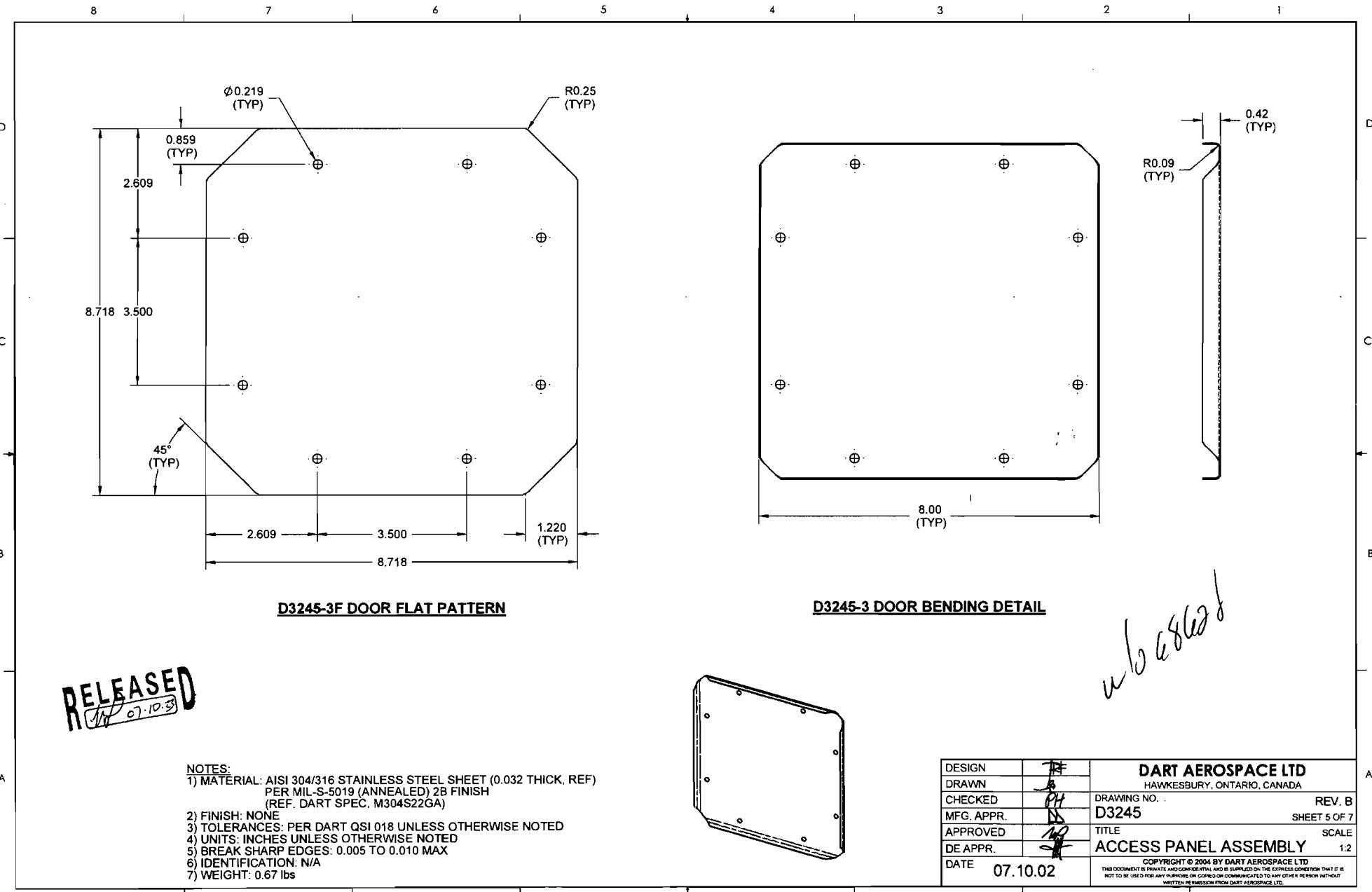
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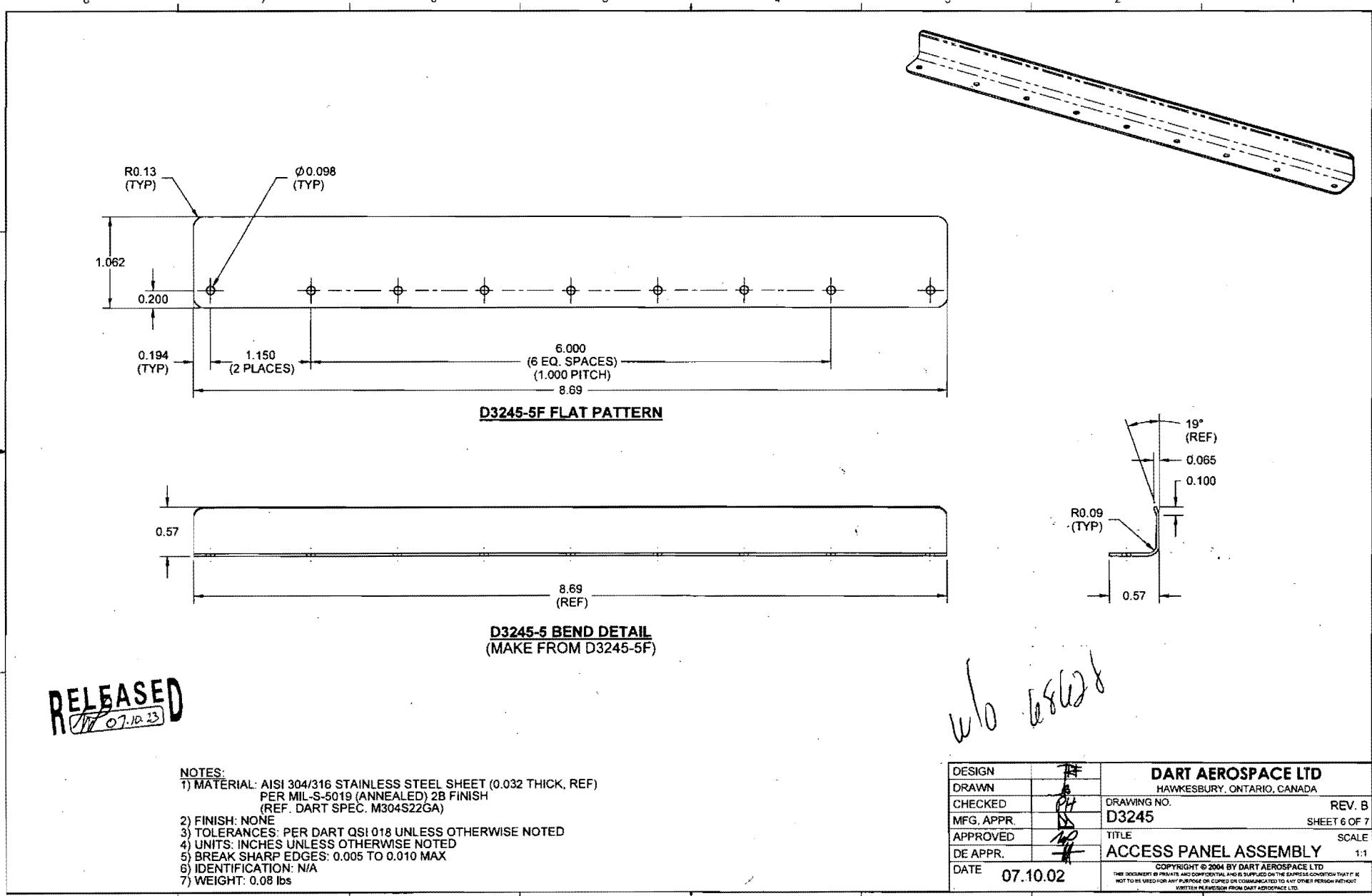
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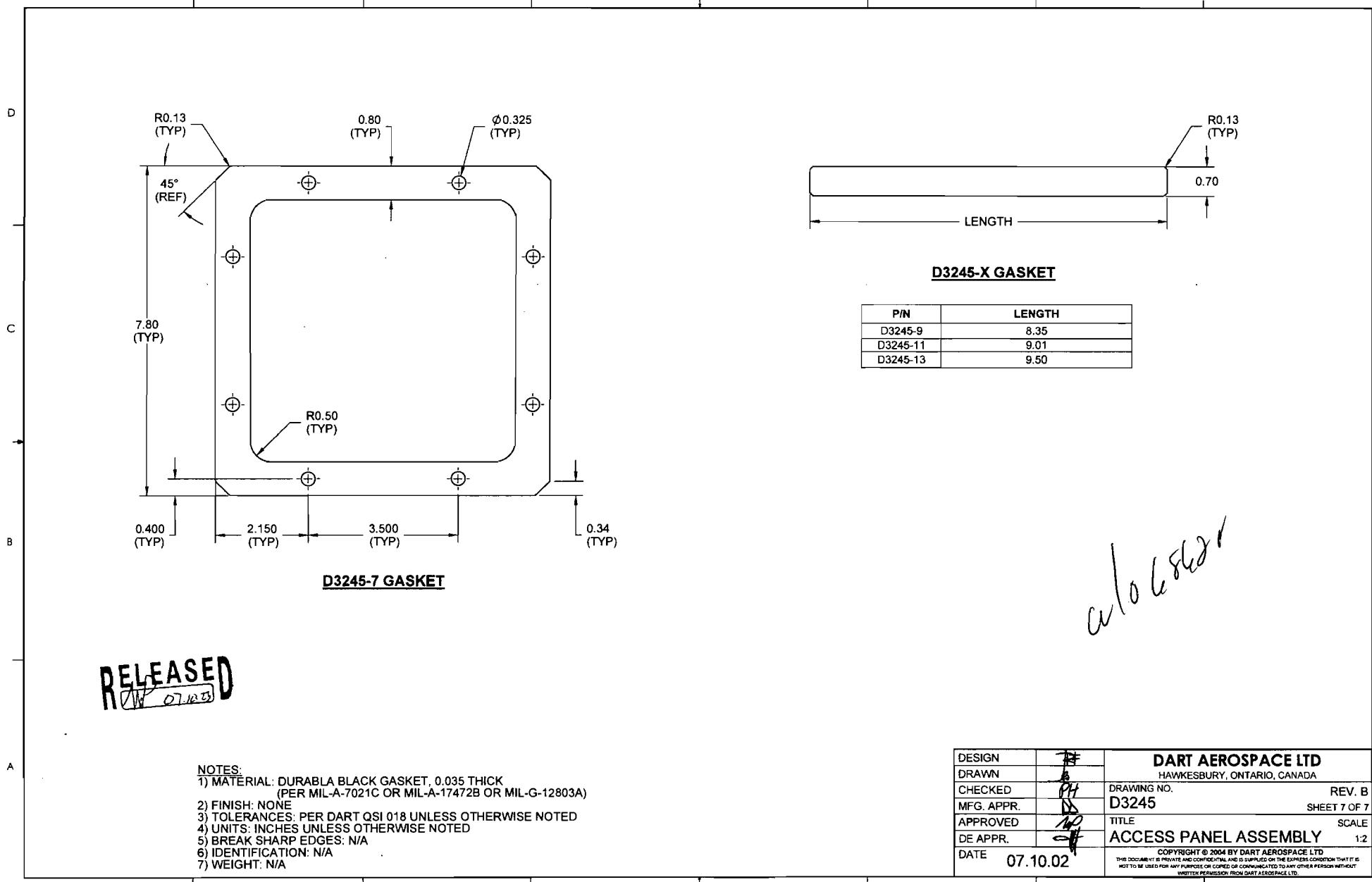
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8 7 6 5 4 3 2 1



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